

5/24

Split 2 C

DART AEROSPACE LTD		Work Order:	23370
Description: Aft Cap		Part Number:	D2646
Dwg: D2646 Rev. B		Qty:	40
Ref:		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.06.07	40
2	PG	Issue P/O: <u>2008094</u> Spin as per Dwg D2646 Material release note required	u	05.06.07	40
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CL	05/06/07	40
4	QC6	Inspect dimensions as per Dwg D2646	J	05-06-24	39
5	GA	Drill using DT8026 as per Dwg D2646. Open holes to 19/64" 1250 per dwg	ml	05-06-24	39
6	GA	Deburr — counter sink	ml	05-06-24	39
7	FP	Acid etch and alodine as per QSI 005 4.1	ml	05/7/4	38
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ml	05.07.11	38
9	QC3	Inspect Powder Coat	ml	06.01.07	36
10	GA	Install Inserts as per Dwg D2646 Pick: Qty Part Number <u>AES10KB116</u> Description <u>Insert</u> Batch <u>M19.014</u>	FC	06.02.28	36
11	QC5	Inspect work to Step 10	ml	06.03.01	36
12	PK	Identify and Stock	ml	06.03.01	36
13	AC	Cost / part: _____	u	06.03.02	
14	DC	Close W/O Inspect Level 21	S	06/03/02	36

Rev	Date	Change	Revised By	Approved
C	98.01.16	Changed Inspection Levels	BW	
D	99.01.04	Added Powder Coat	DM	
E	00.06.22	Removed P/O for powder coat	EC	
F	05.06.07	Reformat	KJ/JLM	

RELEASED

11/5/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-24	4	diameter of caps are .020 - .035 under dimension		Acceptable	 06-03-02	2 05-06-24	 06-07-02	2 05-06-24 S

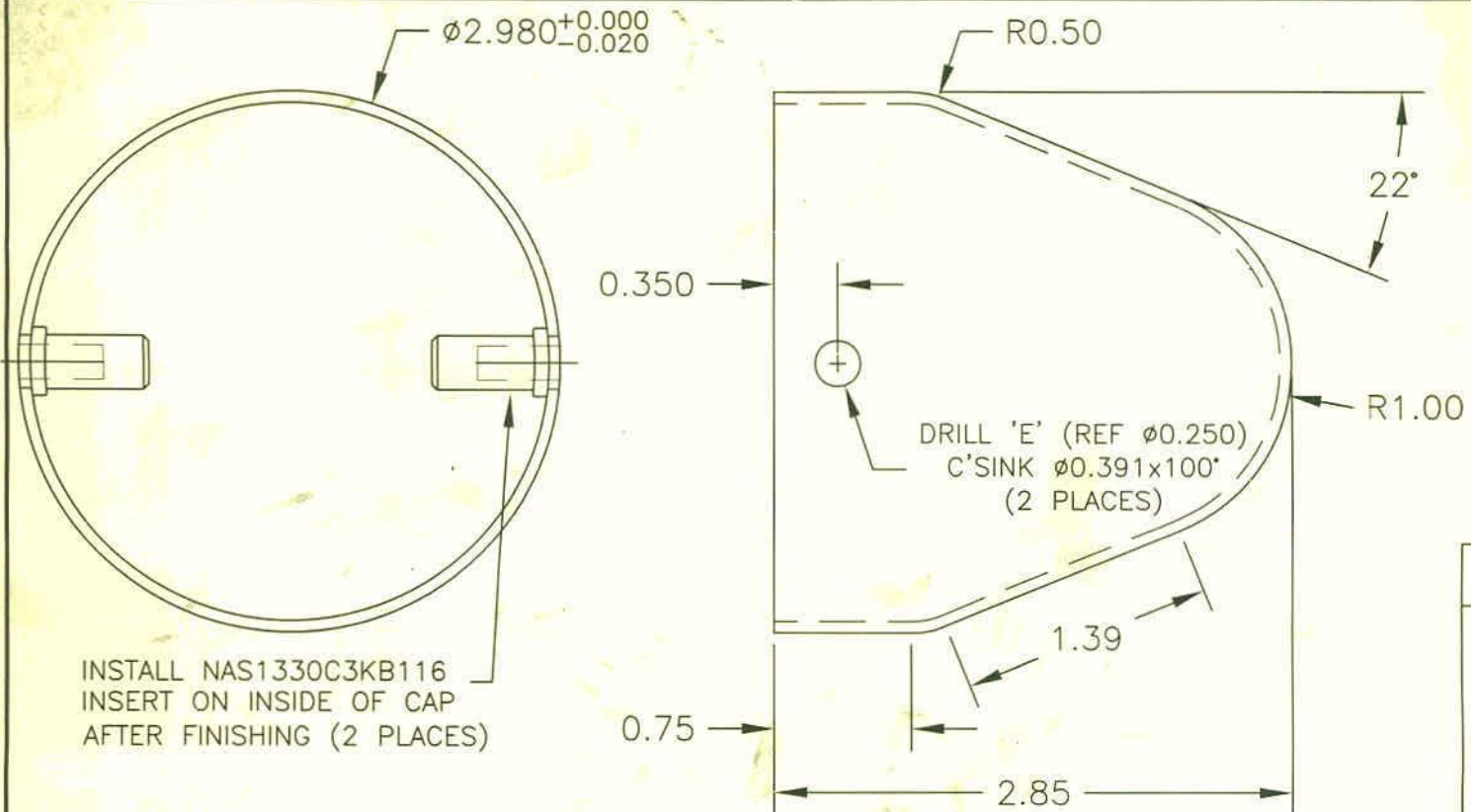
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: Date: 06/03/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.04.01	DRAWING NO.	D2646	REV. B
		TITLE	AFT CAP	SHEET 1 OF 1
		SCALE	1:1	
A	97.03.25	NEW ISSUE		
B	05.04.01	CHANGE TO CLOSED INSERTS		

PRELIMINARY ISSUE



D2646 AFT CAP

- 1) MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1997 by DART Aerospace USA, Inc.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART Aerospace USA, Inc.

NO
WORK ORDER
WITHOUT
CONTROL
SUBJECT TO
RETURN TO
ENGINEER
SHOP

ЗУСІУВАННЯ

МО

АДМ.

ВНП

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 18, 2005
03:08 pm

Work Order No : 0023370^A
Project Name : D2646
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D2646
Description : Aft Cap
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 05-18-05
Est Finish Date : 06-22-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

5/24

DART AEROSPACE LTD	Work Order :	23370A
Description: Aft Cap	Part Number:	D2646
Drawing: D2646 Rev. A	Qty:	40

Step	Location	Procedure	By	Date
1	EXPEDITING	Issue Work Order	HJ	05.05.20
2	PURCHASING	Issue P/O: <u>2008044</u> Spin per Dwg D2646 Material release note required	LL	05.05.24
3	QC	Inspect Level 6 Ensure material release note is attached		
4	METAL	Drill as per Dwg D2646 using DT 8026 Open holes to 19/64"		
5	METAL	Deburr		
6		Acid etch and alodine as per QSI 005 4.1		
7	QC	Inspect Level 7		
8	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3		
9	QC	Inspect Level 3		
10	STORES	Pick: Qty <u>2</u> Part Number <u>ALS7-1032-130L or</u> ALS7-1032-130 or ALS4-1032-130 Description <u>Insert</u> Batch <u> </u>		
11	METAL	Install Inserts as per Dwg D2646		
12	QC	Inspect Level 7		
13	STORES	Identify and Stock		
14	EXPEDITING	Close W/O Cost / Part <u> </u>		

Rev	Date	Revised By	Approved
C	98.01.16	BW	
D	99.01.0	DM	
E	00.06.5	EC	

Do not install
inserts - they are
to change !!

RELEASED
JUN 26 2000

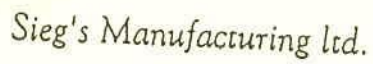
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



604 530-7455 fax 604 530-7490
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

INSPECTION REPORT

CUSTOMER: Dart Aero

PS INVOICE #: 28954 SUPPLIER #: 2008094

DESCRIPTION OF INSPECTION: Spw Parts .064

[illegible]

NOTES OF INSPECTION: check size.

NOTES OF REJECT: NO



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO	COPPER & BRASS SALES INC 22355 WEST ELEVEN MILE ROAD SOUTHFIELD, MI 48034	SHIP TO	COPPER & BRASS SALES INC 6555 E. DAVIDSON DETROIT, MI 48212	CERT NO 0000598687
				DATE 10/26/2004
				SKID NO 322296
				SKID WGT 9,760
				PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792				MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO	050393-8				
ALLOY	1100	TEMPER	O	FORM	COIL		
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000		

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

Handwritten:
HAW
Henry CS198
C/O
Sorel
LTS

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JBFF FREEDY, LAB SUPERVISOR

